

Work Order ID 86336

June-27-12 3:17:34 PM

86336

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 800

8

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 800

8

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/20*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

E *Scrublog*

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

5 *12/07/06 JB*

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

Scrublog

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86336

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Page 2

Item ID: D350-578-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location:

K6612 MCA

190

0.00

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

MCS 12/07/10

MF
12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86336

86336

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 07-01-02 JLM

IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A

Purchased

No

160

Each

562.0000

12

9670 ✓

AN4-17A

Bolt

Location

Loc Qty

Loc Code

ST358

300

116704

0

121541

300

ST359

262

112314

0

121011

200

121068

62

D2182B

Manufactured

No

160

f

122.8682

2.5

20 ✓

D2182B

Rubber Cushion

Location

Loc Qty

Loc Code

ST410

122.86817

63413

1.6

66063

41.61817

73932

79.65

73930

Cut qty 6 at 5.00" long

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 86336

86336

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 8.00

Required Qty: 8.00

D2274

Manufactured No

160 Each

759.0000

D2274

Radius Block

**

12

96

JB

Location

Loc Qty

Loc Code

ST007

759

78233

2

81958

96

83258

210

84199

251

85455

200

84199

D2432

Manufactured No

160 Each

1.0000

D2432

206 (24") Bearpaw

**

12

1613

84063 9x

81044 1x 81

Location

Loc Qty

Loc Code

ST499

1

81044

1

Manufactured No

160 Each

142.0000

D2438

D2438

Clamp

**

6

48 30

81044 12/07/06

Location

Loc Qty

Loc Code

ST456

142

77038

6

83265

28

83266

50

84804

58

84804

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86336

Parent Item: D350-578-011

Parent Item Name: Bearpaw

86336

D350-578-011

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 8.00

Required Qty: 8.00

D2529

Manufactured No

160 Each

761.0000

D2529

Washer

**

Location

Loc Qty

Loc Code

ST010

761

79485

18

81873

243

84435

500

81873

MS210421 4

Purchased No

160 Each

1,920.000

MS210421 4

Nut

**

Location

Loc Qty

Loc Code

ST300

1920

119075

116

121011

193

121444

1311

121652

300

121444

NAS1149D04631

Purchased No

160 Each

2,782.000

NAS1149D0463.1

Washer

**

Location

Loc Qty

Loc Code

ST298

90

104746

3

116805

0

119097

27

121255

49

121708

11

ST299

2689

121912

2689

ST351

3

107321

3

121912

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

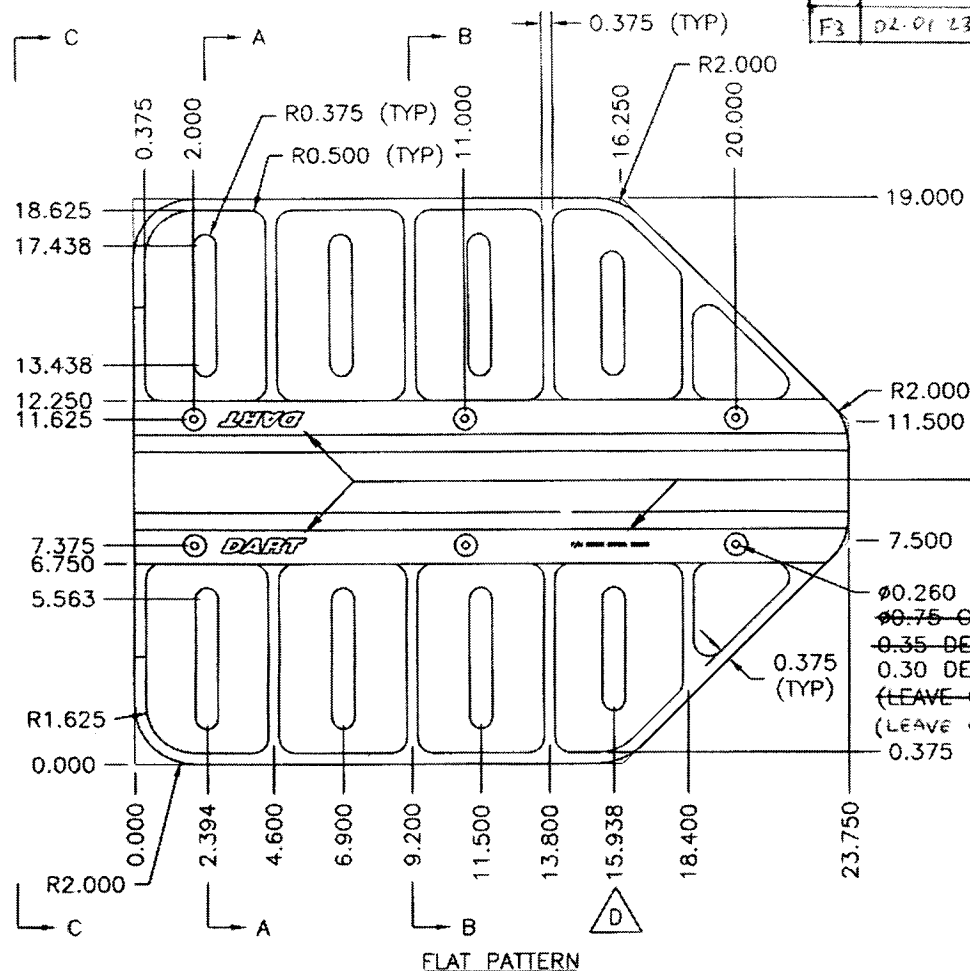
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

F1	99.03.00	ADD DEC 9143
F2	01.03.28	00.03 WAS 00.70 RF
F3	02.01.23	CLARIFY CDR DIMS RF

RELEASED
98.06.17 KE

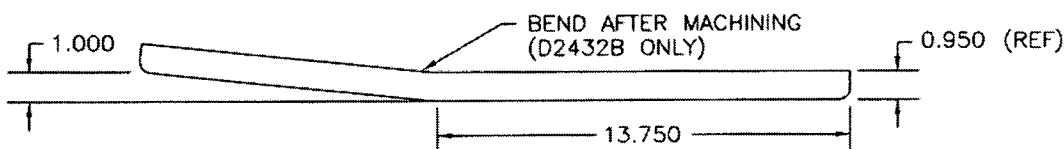
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86336 MLJ
12/06/28



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ & ~~Ø0.93 C'BORE~~
~~0.35 DEEP FROM TOP (MIN.)~~
~~0.30 DEEP FROM BOTTOM~~
~~(LEAVE 0.300 MIN.)~~
(LEAVE 0.650 MIN.)
0.375

EFFECTIVE DECS
9143



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

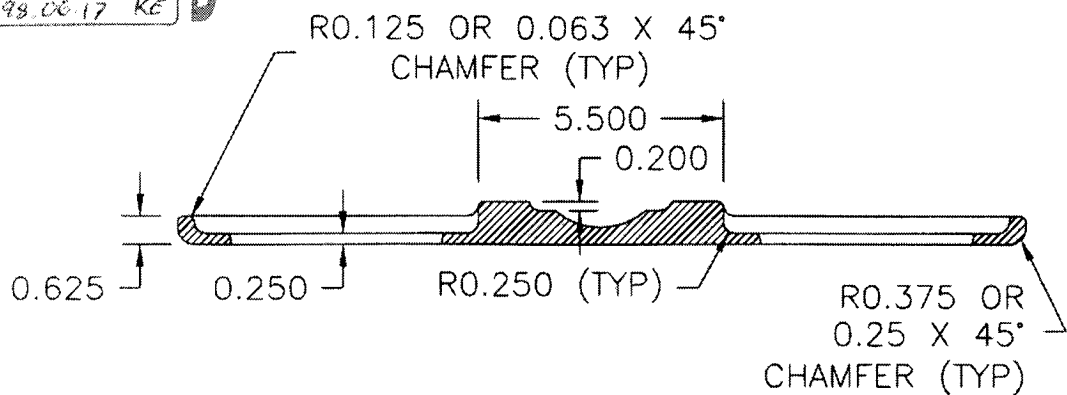
NOTE: Date & initial all entries

80336

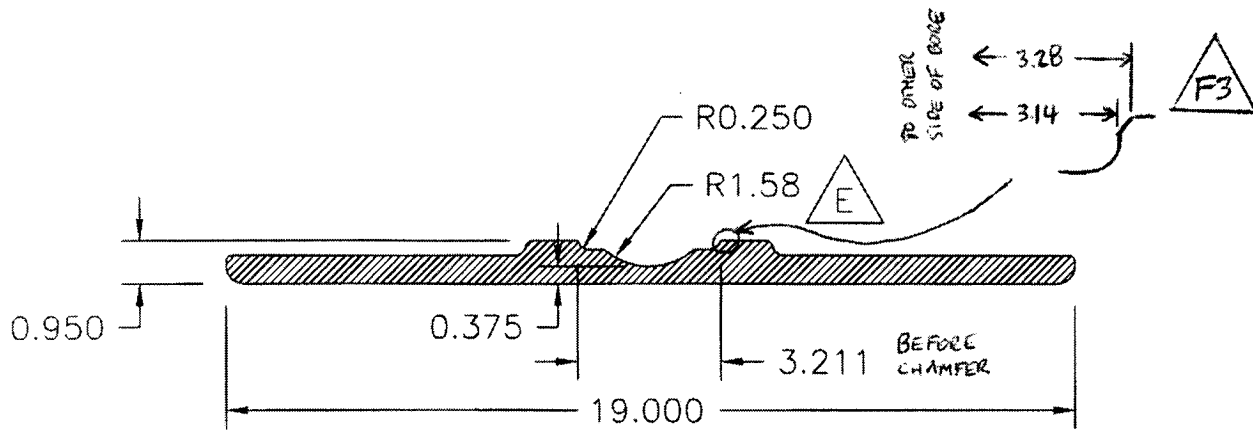


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B. J.	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

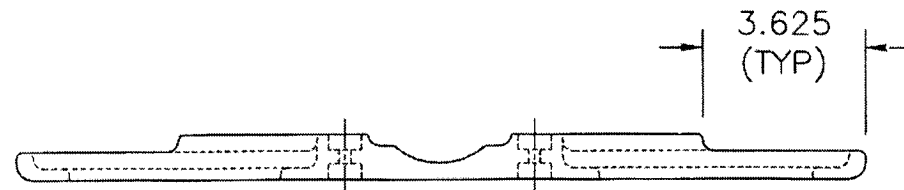
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

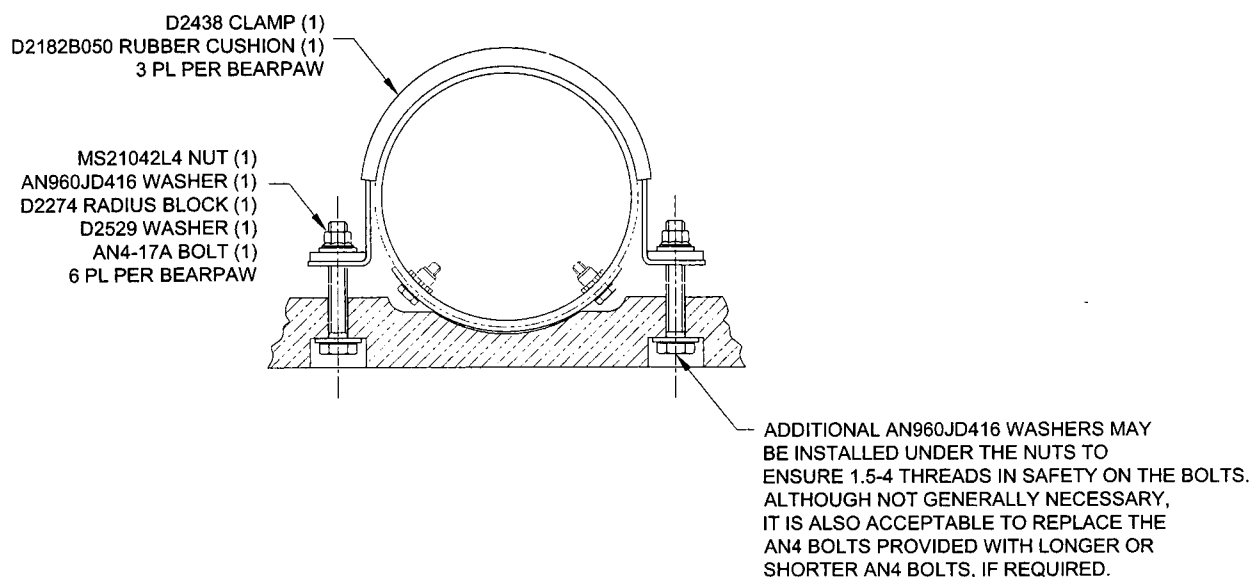
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011-	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

Work Order ID 86336

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Item ID: D350-578-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 800

8

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 800

8

Customer:

Reference:

Approvals: Process Plan: *MLD*

Date: *12/07/12* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

CL 12/07/12

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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